

Work Order ID 121267

June-20-14 10:47:15 AM

~~121267~~ Now
121267

Page 1

Item ID: D5090-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 6/20/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/25/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5090

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr as required

0.00

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

2 2 14-6-25

2 2 14-6-25

Scrap w/ holes
Now in
8/14/2012

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Item ID: D5090-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 6/20/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/25/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	DAS 27 9-89			(2)			
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00	DAS 30 9-89			2			1460/27 68-6 DAS 36 3f 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	DAS 27 9-89			2			1460/26

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Item ID: D5090-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 6/20/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/25/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

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Item ID: D5090-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 6/20/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/25/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

W 14607.07

Picklist Print

Page 1

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Work Order ID: 121267

121267

Parent Item: D5090-3

D5090-3

Parent Item Name: Bracket

Start Date: 6/20/14

Required Date: 6/25/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased			No		sf	234.5200		1			

M6061T6S 040

6061-T6 .040 Sheet

12 14-6-25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	234.52	
m126350	19.52	
m126981	76.91	
m128422	49.79	
m129168	88.3	

m126981

22

4.5

8 7 6 5 4 3 2 1

D

D

C

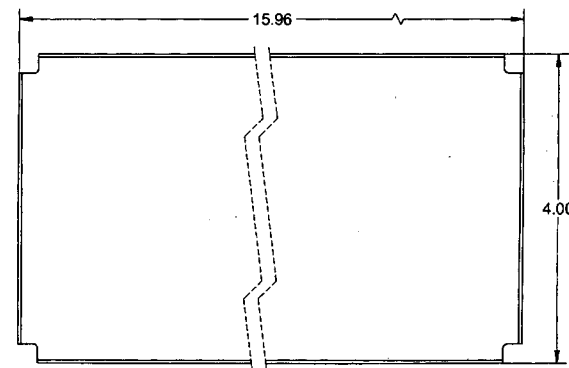
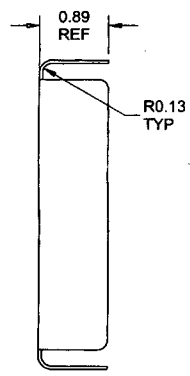
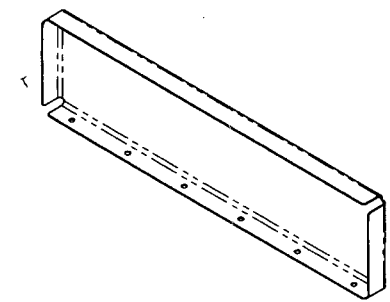
C

B

B

A

A



D5090-3 BRACKET

al6121267

RELEASE
2014-06-16

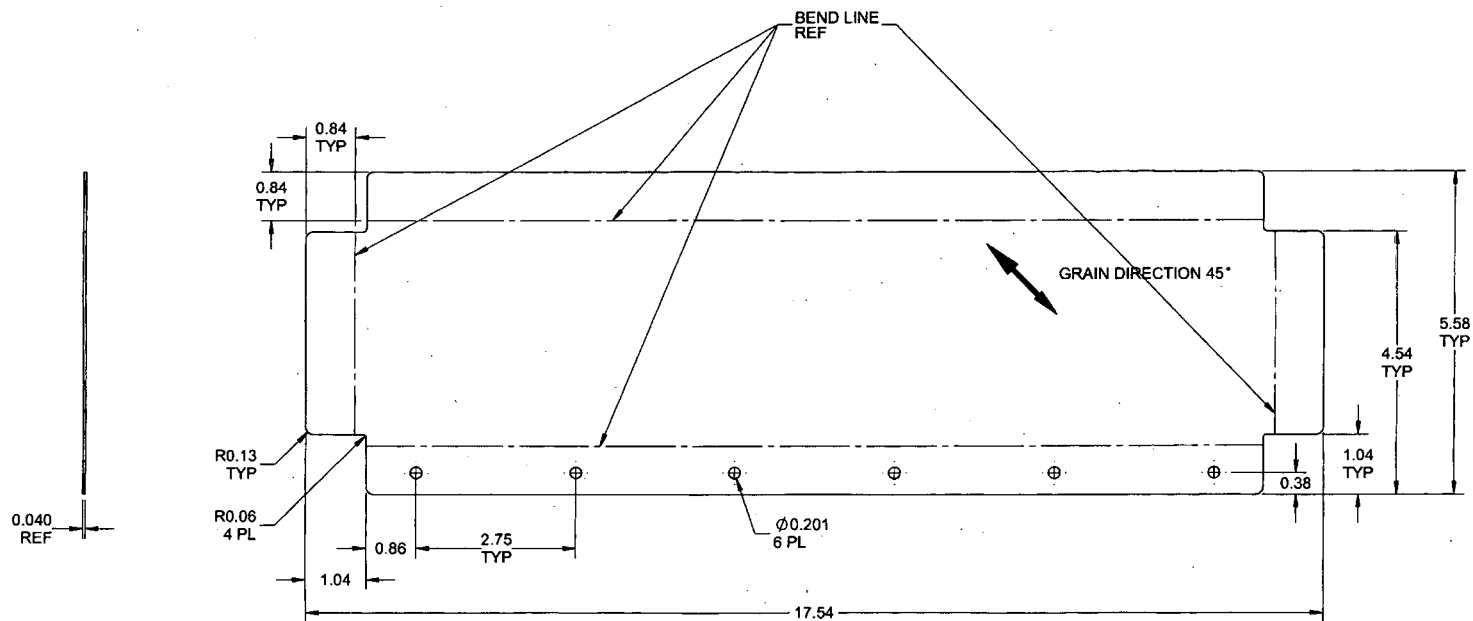
NOTES:

- 1) MATERIAL: MADE FROM D5090-3F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.36 lbs

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5090	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DUCT ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D5090-3F FLAT PATTERN

RELEASED
2014-06-16

NOTES:

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.040

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.36 lbs

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